

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 27565		
Estimate Number	: 10834		
P.O. Number	: N/A	Part Number	: D29332
This Issue	: 6/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2933 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27149	Drawing Revision	: B
		Material	: N/A
		Due Date	: 6/30/2006
Written By	: <u>[Signature]</u>	Qty:	<u>6</u>
Checked & Approved By	: <u>[Signature]</u>	Um:	<u>4</u>
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		

### Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Issue material from stock: 7075-T7351 QQ-A-250/12  
Cut Size 2.0 x 6.25 X 6.00  
Grain Along Long 6.00 Length  
Batch No: B-25344

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

## 5-Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *SD*   Date: 06/08/08

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:41:59 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 27565

Part Number: D29332

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 06/08/20 x 6

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.m 06-08-22

6

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/08/23

~~Q.m 06-08-22~~

6

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

AL 06/08/25 6

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST475

AL 06/08/25 6

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/08/28 6

Job Completion



U 06/08/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27565
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.123	.125	.126		
B	0.100	0.140		.122	.126	.126	.124		
C	0.100	0.140		.124	.129	.129	.129		
D	0.210	0.230		.218	.219	.218	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.259	.259	.259	.259		
L	0.312	0.317	DT8686	.313	.313	.313	.313		
M	0.235	0.240		.239	.238	.239	.239		
N	0.100	0.140		.120	.122	.120	.125		
O	0.540	0.560		.549	.546	.549	.548		
P	0.490	0.510		.501	.495	.498	.496		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.248	.247	.248	.245		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.637	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.319	.319	.319	.319		
X	1.125	1.145		1.136	1.136	1.135	1.140		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JI / SA
Date: 06/08/16 / 06/08/17

Audited by: Er
Date: 06/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27565
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. B	<b>Page 1 of 1</b>

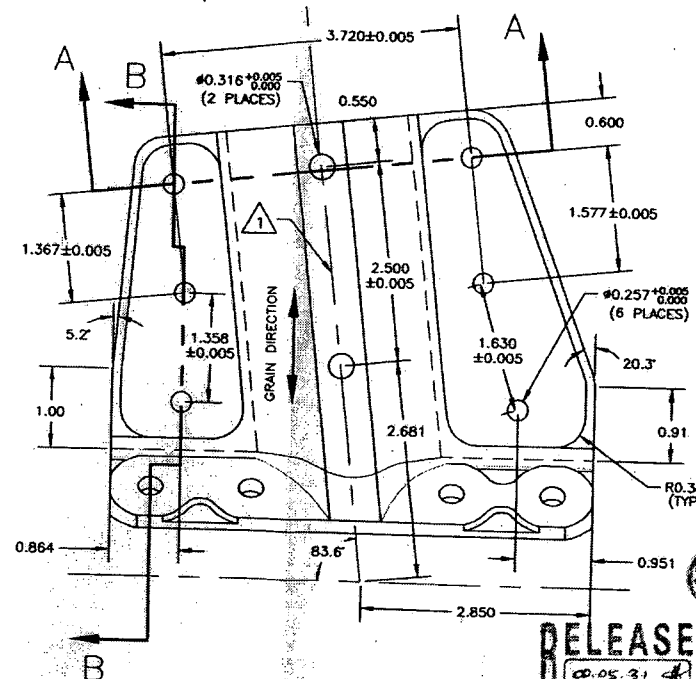
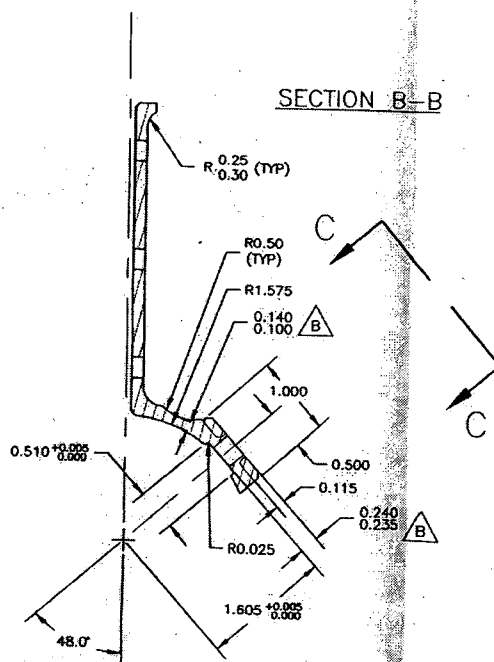
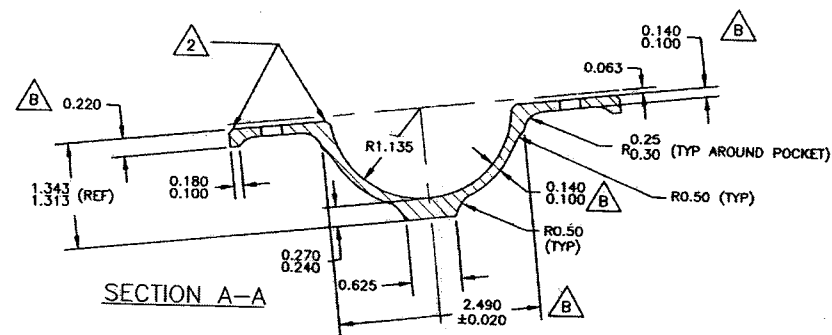
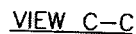
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C	0.100	0.140		.131	.128		/		
D	0.210	0.230		.222	.221		/		
E	1.245	1.255		1.250	1.250		/		
F	1.245	1.255		1.250	1.250		/		
G	2.495	2.505		2.500	2.500		/		
H	0.510	0.515		.514	.514		/		
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AH									
Accept/Reject									

Measured by: SA
Date: 06.08.17

Audited by: E
Date: 06/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (Q0-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°

SHOP COPY  
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UNCONTROLLED COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 27565

RELEASE  
00-05-31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL	REV. B
A	99.10.29	NEW ISSUE	SHEET 1 OF 1
DESIGN <i>JS</i>	DRAWN BY RT	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA	SCALE
CHECKED <i>JS</i>	APPROVED <i>JS</i>	DRAWING NO. D2933	2
DATE 00.05.29		TITLE SADDLE INSIDE	

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